

CLAIM AMENDMENTS

1 - 15. (canceled)

1 16. (currently amended) A method of manufacturing a
2 polyethylene terephthalate packaging web, the method comprising the
3 steps of:

4 feeding waste polyethylene terephthalate raw material
5 containing dirt and with no substantial pretreatment to a twin-
6 screw extruder at a feed rate while rotating screws of the extruder
7 at a rotation rate to plastify the material and extrude a
8 polyethylene terephthalate melt from the extruder;

9 degassing an interior of the extruder during the
10 extrusion of the polyethylene terephthalate melt therefrom;

11 passing the melt through a sieve filter and thereby
12 separating the dirt from the melt;

13 measuring melt pressure upstream and downstream of the
14 sieve filter;

15 controlling one of the rates of the extruder in
16 accordance with the measured melt pressures;

17 backflushing the sieve filter with the melt and thereby
18 forcing the dirt from the sieve filter in accordance with the melt
19 pressures measured upstream and downstream of the sieve filter;

20 outputting a strip of the polyethylene terephthalate melt
21 from a spinning head located downstream of the extruder; and

22 cooling and stretching the strip of the polyethylene
23 terephthalate to form the polyethylene terephthalate packaging web.

1 17. (previously presented) The method defined in claim
2 16 wherein the raw material is at least in part PET flakes formed
3 by comminuting PET bottles.

1 18. (previously presented) The method defined in claim
2 16 wherein the raw material is supplied to the extruder with at
3 least one metering screw.

1 19. (previously presented) The method defined in claim
2 18 wherein the metering screw supplies the raw material to the
3 extruder such that flights of the extruder screws are filled only
4 to 25% to 60% with the polyethylene terephthalate raw material.

1 20. (previously presented) The method defined in claim
2 19 wherein the flights of the extruder screws are filled to 30% to
3 50% with the polyethylene terephthalate raw material.

1 21. (currently amended) The method defined in claim 16
2 wherein the screws of the extruder are driven in the same [[sense]]
3 direction.

1 22. (previously presented) The method defined in claim
2 16 wherein the interior of the extruder is degassed by connecting
3 at least one suction pump thereto.

1 23. (previously presented) The method defined in claim
2 16, further comprising the step of feeding at least one chain-
3 lengthening substance to the interior of the extruder.

1 24. (previously presented) The method defined in claim
2 23 wherein the chain-lengthening substance is a lactam or an
3 oxazole derivative.

1 25. (previously presented) The method defined in claim
2 16 wherein the melt is fed to the head with at least one melt pump.

1 26. (previously presented) The method defined in claim
2 16 wherein the strip is cooled in a liquid.

1 27. (previously presented) The method defined in claim
2 26 wherein the liquid is a water bath.

1 28. (previously presented) The method defined in claim
2 16 wherein the one rate is the rotation rate.

1 29. (previously presented) The method defined in claim
2 16 wherein the one rate is the feed rate.

1 30. (new) The method defined in claim 16 wherein the
2 strip is stretched by passing it through two stretching devices.

1 31. (new) The method defined in claim 30, further
2 comprising after stretching and cooling the strip the step of
3 guiding the strip through a furnace and heating it
4 therein above its glass temperature.

1 32. (new) The method defined in claim 31, further
2 comprising after stretching and cooling the strip the step of
3 again stretching the strip and thereafter
4 heating the strip in a fixing device.

1 33. (new) The method defined in claim 32, further
2 comprising after heating the strip in a fixing device the step of
3 cooling the strip and thereafter
4 stretching the strip.

1 34. (new) A method of manufacturing a polyethylene
2 terephthalate packaging web, the method comprising the steps of:
3 feeding waste polyethylene terephthalate raw material
4 containing dirt and with no substantial pretreatment to a twin-
5 screw extruder at a feed rate while rotating screws of the extruder

6 at a rotation rate to plastify the material and extrude a
7 polyethylene terephthalate melt from the extruder;
8 feeding at least one chain-lengthening substance
9 including an oxazole derivative to the interior of the extruder;
10 degassing an interior of the extruder during the
11 extrusion of the polyethylene terephthalate melt therefrom;
12 passing the melt through a sieve filter and thereby
13 separating the dirt from the melt;
14 measuring melt pressure upstream and downstream of the
15 sieve filter;
16 controlling one of the rates of the extruder in
17 accordance with the measured melt pressures;
18 backflushing the sieve filter with the melt and thereby
19 forcing the dirt from the sieve filter in accordance with the melt
20 pressures measured upstream and downstream of the sieve filter; and
21 outputting a strip of the polyethylene terephthalate melt
22 from a spinning head located downstream of the extruder.

1 35. (new) The method defined in claim 34, further
2 comprising the step of:

3 cooling and stretching the strip of the polyethylene
4 terephthalate to form the polyethylene terephthalate packaging web.

1 36. (new) The method defined in claim 35 wherein the
2 strip is stretched by passing it through two stretching devices.

1 37. (new) The method defined in claim 36, further
2 comprising after stretching and cooling the strip the step of
3 guiding the strip through a furnace and heating it
4 therein above its glass temperature.

1 38. (new) The method defined in claim 37, further
2 comprising after stretching and cooling the strip the step of
3 again stretching the strip and thereafter
4 heating the strip in a fixing device.

1 39. (new) The method defined in claim 38, further
2 comprising after heating the strip in a fixing device the step of
3 cooling the strip and thereafter
4 stretching the strip.

1 40. (new) A method of manufacturing a polyethylene
2 terephthalate packaging web, the method comprising the steps of:
3 feeding waste polyethylene terephthalate raw material
4 containing dirt and with no substantial pretreatment to a twin-
5 screw extruder at a feed rate while rotating screws of the extruder
6 at a rotation rate to plastify the material and extrude a
7 polyethylene terephthalate melt from the extruder;
8 feeding at least one chain-lengthening substance
9 including an oxazole derivative to the interior of the extruder;
10 degassing an interior of the extruder during the
11 extrusion of the polyethylene terephthalate melt therefrom;

12 passing the melt through a sieve filter and thereby
13 separating the dirt from the melt;
14 measuring melt pressure upstream and downstream of the
15 sieve filter;
16 controlling one of the rates of the extruder in
17 accordance with the measured melt pressures;
18 backflushing the sieve filter with the melt and thereby
19 forcing the dirt from the sieve filter in accordance with the melt
20 pressures measured upstream and downstream of the sieve filter;
21 outputting a strip of the polyethylene terephthalate melt
22 from a spinning head located downstream of the extruder; and
23 cooling and stretching the strip of the polyethylene
24 terephthalate to form the polyethylene terephthalate packaging web.

1 41. (new) The method defined in claim 40 wherein the
2 strip is stretched by passing it through two stretching devices.

1 42. (new) The method defined in claim 41, further
2 comprising after stretching and cooling the strip the step of
3 guiding the strip through a furnace and heating it
4 therein above its glass temperature.

1 43. (new) The method defined in claim 42, further
2 comprising after stretching and cooling the strip the step of
3 again stretching the strip and thereafter
4 heating the strip in a fixing device.

1 44. (new) The method defined in claim 43, further
2 comprising after heating the strip in a fixing device the step of
3 cooling the strip and thereafter
4 stretching the strip.